

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000108**Date Inspected:** 12-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification** **Fracture Critical**
Mechanical Testing, describe:See Below**Index Lot #:** B41-003-07a**Witness Lot #:** B31-004-07**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Welder:** Zhang Xing Jin**ID #:** N/A**Joint Description:** Non Standard

N/A

WPS ID #: PWPS-B-T-3231-1

N/A

Base Metal: ASTMA709 Gr HPS485W

N/A

PQR ID #: HP2006120

N/A

Thickness: 75mm

N/A

Process: FCAW-G

N/A

Electrode Spec/Class: A5.20/E71T-1

N/A

Positions: 1G

N/A

Backing Material: ASTMA709 Gr HPS485W

N/A

CWI: Liu Liu

N/A

Average Amps:

N/A

AWS Code: D1.5-2002

N/A

Average Volts:

N/A

Applicable Sec: 5.12

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

On this date the QA representative Joe Lanz was present for observations relative to the weld procedure qualification performed by Zhenhua Port Machinery Company (ZPMC). The QA inspector observed Charpy V-notch tests in accordance with AWS D1.5-96 Section 5.18.5. The test machine calibration was verified. ZPMC personnel verified the specimen dimensions. The weld metal specimens were tested at -30 degrees. C. and the heat affected zone (HAZ) specimens were tested at 4 degrees C. The tests were performed and the results recorded. The QA observed All Weld Metal Tensile test in accordance with AWS D1.5-96 Section 5.18.4. Test Machine calibration was verified. ZPMC personnel verified specimen dimensions. The test was performed and results recorded. The QA inspector observed side bend tests in accordance with AWS D1.5-96 Section 5.18.3. ZPMC personnel performed tests and recorded results. The QA inspector observed 2 reduced section tensile coupon tests in accordance with AWS D1.5-96 Section 5.18.1. The test machine calibration was verified. ZPMC personnel verified specimen dimensions. The test was performed and results recorded. The testing appeared to comply with the contract documents. Caltrans lot number B31-004-07 was assigned for tracking purposes.

Summary of Conversations:

WELDING WITNESS REPORT

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No relevant conversations on this date.

Observed welding, testing or results: is in general conformance with the contract requirements.
is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz, Joe	Quality Assurance Inspector
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Reviewed By:	Wright, Mark	QA Reviewer
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